

Work Order ID 84049 -2

84049

Page 1

Item ID: D4016-1

Accept

N900040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Hinge Half, Base

Start Date: 01/05/2012 Start Qty: 18.00

18

Cust Item ID:

Required Date: 07/05/2012 Req'd Qty: 18.00

18

Customer:

Reference:

Approvals: Process Plan: *MLJ*

Date: *12/05/01*

Tooling:

Date:

Run Start *NR1*

QC:

Date:

SPC (Y/N):

Date:

Stop *NR2*

| Sequence ID/ Work Center ID | Operation Description | Set Up/ Run Hours | Tool ID | Tool # | Plan Code | Accept Qty | Reject Qty | Reject Number | Insp. Stamp |
|--------------------------------|--------------------------|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|
|--------------------------------|--------------------------|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|

Draw Nbr

Revision Nbr

D4016

A

100

Cut blanks as per folio

0.00

100

OK 12/05/22

Bandsaw

Memo

0.00

Jeaspa Bandsaw

CUT BLANK 1.00" LONG

110

0.00

110

OK 12/05/22

HAAS 1

Memo

0.00

HAAS CNC vertical machine #1

MACHINE AS PER FOLIO FA869 AND DWG

FOLIO REV: *AA*

DWG REV: *A*

DEBURR

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
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| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Cust Item ID:

Required Date: 07/05/2012 Req'd Qty: 18.00

18

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start *NR1*

QC:

Date:

SPC (Y/N):

Date:

Stop *NR2*

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

120

QC2- Inspect parts off machine FAI/FAIB

0.00

120

QC

Memo

0.00

Quality Control

130

QC8- Inspect parts - second check

0.00

130

QC

Memo

0.00

Quality Control

160

Identify as per dwg & Stock Location:

0.00

160

Packaging

Memo

0.00

Packaging

SL 12-05-28

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
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NOTE: Date & initial all entries

Work Order ID 84049

84049

Page 3

May-01-12 2:33:32 PM

Item ID: D4016-1

Accept

N900040100

Setup Start *NS1*

Revision ID:

Item Name: Hinge Half, Base

Stop *NS2*

Start Date: 01/05/2012 Start Qty: 18.00

18

Cust Item ID:

Required Date: 07/05/2012 Req'd Qty: 18.00

18

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start *NR1*

QC:

Date:

SPC (Y/N):

Date:

Stop *NR2*

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

170

QC21- Final Inspection - Work Order Release

0.00

170

QC

Memo

0.00

Quality Control

12/5/29 J

MF
12-05-28

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
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NOTE: Date & initial all entries

Picklist Print

May-01-12 2:33:35 PM

Page 1

Work Order ID: 84049

84049

Parent Item: D4016-1

D4016-1

Parent Item Name: Hinge Half, Base

Start Date: 01/05/2012

Required Date: 07/05/2012

Start Qty: 18.00

Required Qty: 18.00

Comments:

IPP REV:A NEW ISSUE 09-11-27 JLM VERIFIED BY :DD IPP Rev:B
as per dwg REV.A DD 10.02.22 verified by:EC

| Component Item ID/ Item Name | Replacement Item ID | Mfg/ Purch | Bin Item | Primary Location | Last Location | Route Seq ID | Unit of Measure | Qty on Hand | Qty per Kit | Total Qty | Qty Issued | Date Issued | Status |
|---------------------------------|------------------------|---------------|-------------|---------------------|------------------|-----------------|--------------------|----------------|-------------|--------------|---------------|----------------|--------|
| M304B1.000X1.000 | | Purchased | No | | | 100 | f | 1.0470 | 0.08 | 1.44 | | | |

M304B1 000X1 000

304 bar 1.00 x 1.00

**

Location

Loc Qty

Loc Code

MAT050

1.047

113290

1.047

M304B1.5X1.5

M116719

~~1149~~
.72"

OK 12/05/22

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

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|--------------------------------------|---------------|-----------------------------|
| DART AEROSPACE LTD | | Work Order: 84049 |
| Description: Hinge Half, Base | | Part Number: D4016-1 |
| Inspection Dwg: D4016 | Rev: A | Page 1 of 1 |

FIRST ARTICLE INSPECTION CHECKLIST

| Drawing Dimension | Tolerance | Actual Dimension | Accept | Reject | Method of Inspection | Comments |
|-------------------|---------------|------------------|--------|--------|----------------------|----------|
| 0.875 | +/-0.010 | .875 | — | | Vein H.L. PL | |
| 0.25 | +/-0.030 | .241 | — | | " | |
| 0.38 | +0.030/-0.000 | .387 | — | | " | |
| R0.03 | +/-0.030 | R.030 | — | | " | |
| 0.13 | +/-0.030 | .129 | — | | " | |
| 0.88 | +/-0.030 | .875 | — | | " | |
| Ø0.257 | +0.006/-0.001 | Ø.2585 | — | | " | |
| R0.38 | +/-0.030 | R.375 | — | | " | |
| 0.500 | +/-0.030 | .500 | — | | " | |
| 0.75 | +/-0.030 | .754 | — | | " | |
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| Measured by: <i>amf</i> | Audited by: <i>SL</i> | Preliminary Approval: |
| Date: 12/05/22 | Date: 12-05-23 | Date: |

| Rev | Date | Change | Revised by | Approved |
|-----|----------|-----------|-----------------------|--------------------|
| A | 10.06.07 | New Issue | KJ <i>[Signature]</i> | <i>[Signature]</i> |

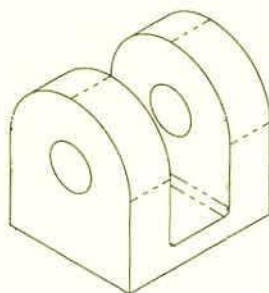
| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
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Part No: _____ FAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

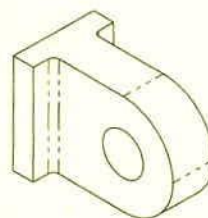
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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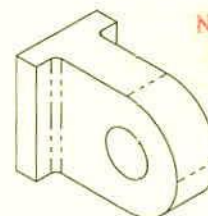
NOTE: Date & initial all entries



D4016-1 HINGE HALF, BASE



D4016-3 HINGE HALF, LID



D4016-5 HINGE HALF, LIGHT LID

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 87049 m

WORK ORDER
NO. 84049 MLJ
12/05/01

RELEASED
2010-02-16
MD

| | | | |
|------------|-------------|-------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|--------------|
| A | NEW ISSUE | JPH | 10.01.29 |
| REV. | DESCRIPTION | | BY DATE |
| DESIGN | AJS | DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA | |
| DRAWN | AJS | | |
| CHECKED | GO | DRAWING NO. | REV. A |
| MFG. APPR. | BS | D4016 | SHEET 1 OF 2 |
| APPROVED | NO | TITLE | SCALE |
| DE APPR. | HT | BASKET HINGE | NTS |
| DATE | 10.01.29 | COPYRIGHT © 2015 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL. IT IS NOT TO BE REPRODUCED OR TRANSMITTED IN ANY FORM OR BY ANY MEANS WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD. | |

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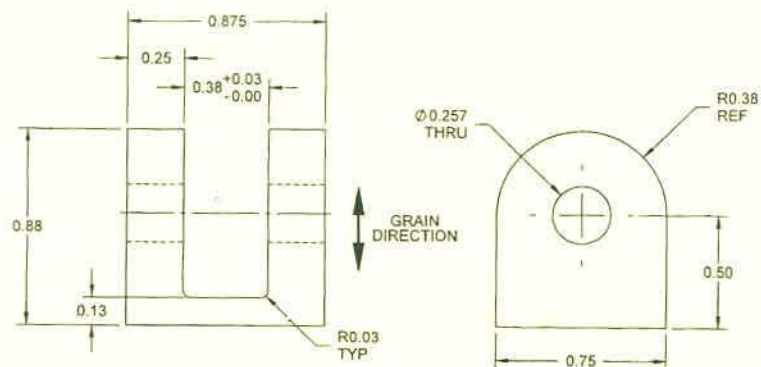
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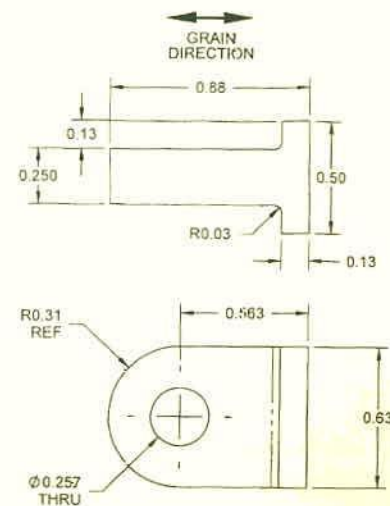
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NOTE: Date & initial all entries

84049



D4016-1 HINGE HALF, BASE



D4016-3 HINGE HALF, LID

D4016-5 HINGE HALF, LIGHT LID

NOTES:

- 1) MATERIAL -1 & -3: 304/316 STAINLESS STEEL BAR, PER ASTM A276
REF DART SPEC M304B
- 5: 6061-T6/T651/T6511/T62 ALUMINUM BAR
PER QQ-A-225/8 OR AMS-QQ-A-225/8 (OR AMS4117/4128/4115/4116)
OR QQ-A-200/8 OR AMS-QQ-A-200/8 (OR AMS 4160)
OR ASTM B211 OR ASTM B221
REF DART SPEC M6061T6B
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT -1: 0.09 lbs
-3: 0.04 lbs
-5: 0.01 lbs

RELEASED
2010-02-16

| | | | |
|------------|--------------------|--------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|--------------|
| DESIGN | AJS | DART AEROSPACE LTD | |
| DRAWN | AJS | HAWKESBURY, ONTARIO, CANADA | |
| CHECKED | <i>[Signature]</i> | DRAWING NO. | REV. A |
| MFG. APPR. | <i>[Signature]</i> | D4016 | SHEET 2 OF 2 |
| APPROVED | <i>[Signature]</i> | TITLE | SCALE |
| DE APPR. | <i>[Signature]</i> | BASKET HINGE | NTS |
| DATE | 10.01.29 | COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS UNCLASSIFIED AND IS RELEASED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSES OR DISSEMINATED IN ANY FORM WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD | |

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